



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5380-1
Job Sheet 185911



Part No: D5380-1

Part Name: Support

Job Qty: 12 pcs

DAS
21
9-00



Part Weight: 0 lbs

Job Created: 11/6/18

Due Date: 11/22/18

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Jesse White

Description:

Note: DWG REV C SHEET 1 IPP REV.A NEW ISSUE JFS 16/02/02 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	HAAS 4 Axis S128139.	12 pcs	11/22/18		0.73	41.38	HAAS - 1	
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	///
110	QC 2	12 pcs	11/22/18		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	///
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	

120 QC 8	12 pcs	11/22/18	0.00	0.00	QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	5.0.1. 19-02-06
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
121 QC 5	12 pcs	11/22/18	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 38	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	40 DAS
					QC 5 - 50	9-89 9
					QC 5 - 30	9-89 9-89
130 Packaging 3-1 - Stock - B4B	12 pcs	11/22/18	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	

				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B	LG056 A2 19-3-5				
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B	DAG				
140 QC 21 - SA				12 pcs	11/22/18	0.00	0.00	QC 21 - SA - 21	21 MAR 05 2019
								QC 21 - SA - 70	9-89
Part Op 100 - (HAAS CNC Vertical Machine) Machine as per Folio FB458 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 121 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) LOCATION : LG0546 140 - (QC21- Final Inspection - Work Order Release)									
Job BOM									
Part / Item		Component Name		Quantity		Operation		Container	
D5380-1TRN		Support Turning Detail		6 pcs (.5 ea)		100-HAAS 4 Axis			
Job Allocations									
Operation		Component Part		Required		Inventory		Allocated	
100-HAAS 4 Axis		D5380-1TRN		6		6		0	
Part Specifications									
Specifications could not be found.									

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D5380-1
Job Sheet 185911



Part No: D5380-1
Part Name: Support

Part Weight: 0 lbs
Job Created: 11/6/18
Due Date: 11/22/18
Type: Stock
Note: DWG REV C SHEET 1 IPP REV.A NEW ISSUE JFS 16/02/02 VERIFIED BY: DD
Ship Via:

Job Qty: 12 ea

Status: New
Job Tracking No:
Created By: Jesse White
Description:

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		11/22/18	0.00	0.00	Start Up Machining-4		
100	CNC Vertical Machining	12 pcs		11/22/18	0.73	41.38	HAAS1-2		
110	QC	12 pcs		11/22/18	0.00	0.00	QC2 Machining-4		
120	QC	12 pcs		11/22/18	0.00	0.00	QC8 Machining-4		
121	QC	12 pcs		11/22/18	0.00	0.00	QC5		
130	Packaging	12 pcs		11/22/18	0.00	0.00	Packaging3-2		
140	QC21-SA	12 Ea		11/22/18	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FB458
Descriptions: 130 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5380-1TRN	Support Turning Detail	6 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5380-1TRN	6	0	0

Part Specifications

Specifications could not be found.

Plex 11/6/18 1:04 PM dart.white.jesse

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DART AEROSPACE LTD		Work Order:	185911
Description: Support		Part Number:	D5380-1
Inspection Dwg: D5380	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	3.890	3910		3.903	3.902	3.904	3.904	3.903
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.550	3.550	3.550	3.550	3.550
AD	1.765	1.785		1.774	1.774	1.775	1.775	1.775
AE	0.590	0.610		0.600	0.600	0.600	0.600	0.600
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.300	2.300	2.300	2.300
AH	3.550	3.560		3.557	3.556	3.557	3.557	3.555
AI	0.625	0.630		0.625	0.625	0.625	0.625	0.625
AJ	0.528	0.548		0.537	0.535	0.533	0.534	0.534
AK	0.498	0.518		0.508	0.508	0.508	0.508	0.508
AL	0.494	0.514		0.504	0.504	0.504	0.504	0.504
AM	1.094	1.114		1.104	1.104	1.104	1.104	1.104
AN	0.220	0.222		0.2201	0.2202	0.2205	0.220	0.221
AO	0.490	0.510		0.504	0.504	0.501	0.502	0.501
AP	1.250	1.270		1.260	1.260	1.260	1.260	1.260
AQ	2.465	2.485		2.473	2.473	2.471	2.472	2.472
AR	1.405	1.425		1.412	1.412	1.412	1.412	1.412
AS	0.050	0.110		0.080	0.080	0.080	0.080	0.080
AT	0.300	0.360		0.339	0.339	0.339	0.339	0.339
AU	0.100	0.125		0.111	0.110	0.110	0.110	0.110
AV	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AW	0.030	0.090		0.060	0.060	0.060	0.060	0.060
AX	0.010	0.030		0.020	0.020	0.020	0.020	0.020
AY	0.115	0.135		0.125	0.125	0.125	0.125	0.125
AZ	0.640	0.660		0.650	0.650	0.650	0.650	0.650
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				✓				

Measured by:	KJ	Date:	19-01-27
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Audited by:		Date:	
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Preliminary Approval:		Date:	
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	85911
Description: Support		Part Number:	D5380-1
Inspection Dwg: D5380	Rev: BC	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	3.890	3910		3.903	3.902	3.902	3.904	3.904
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.550	3.550	3.550	3.550	3.550
AD	1.765	1.785		1.775	1.775	1.775	1.775	1.775
AE	0.590	0.610		0.600	0.597	0.598	0.599	0.599
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.297	2.297	2.297	2.297
AH	3.550	3.560		3.555	3.553	3.554	3.557	3.558
AI	0.625	0.630		0.625	0.625	0.625	0.625	0.625
AJ	0.528	0.548		0.534	0.537	0.537	0.539	0.539
AK	0.498	0.518		0.508	0.504	0.504	0.505	0.505
AL	0.494	0.514		0.504	0.504	0.504	0.505	0.505
AM	1.094	1.114		1.104	1.098	1.100	1.100	1.100
AN	0.220	0.222		0.220	0.220	0.220	0.221	0.221
AO	0.490	0.510		0.500	0.499	0.499	0.499	0.499
AP	1.250	1.270		1.260	1.262	1.262	1.258	1.258
AQ	2.465	2.485		2.472	2.474	2.474	2.474	2.474
AR	1.405	1.425		1.412	1.412	1.411	1.411	1.411
AS	0.050	0.110		0.080	0.086	0.086	0.085	0.085
AT	0.300	0.360		0.329	0.330	0.330	0.328	0.328
AU	0.100	0.125		0.110	0.108	0.108	0.109	0.109
AV	0.220	0.280		0.250	0.250 R	0.250 R	0.250 R	0.250 R
AW	0.030	0.090		0.060	0.060 R	0.060 R	0.060 R	0.060 R
AX	0.010	0.030		0.020	0.020	0.020	0.020	0.020
AY	0.115	0.135		0.125	0.125 R	0.125 R	0.125 R	0.125 R
AZ	0.640	0.660		0.650	0.650 R	0.650 R	0.650 R	0.650 R
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				✓				

Measured by:	mtt	Date:	2019/01/30
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Audited by:		Date:	
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Preliminary Approval:		Date:	
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	

5120139

DART AEROSPACE LTD		Work Order:	185911
Description: Support		Part Number:	D5380-1
Inspection Dwg: D5380	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	3.890	3910		3.904				
AB	0.256	0.263		.256				
AC	3.540	3.560		3.552				
AD	1.765	1.785		1.775				
AE	0.590	0.610		.598				
AF	1.140	1.160		1.150				
AG	2.290	2.310		2.298				
AH	3.550	3.560		3.556				
AI	0.625	0.630		.625				
AJ	0.528	0.548		.535				
AK	0.498	0.518		.508				
AL	0.494	0.514		.508				
AM	1.094	1.114		1.104				
AN	0.220	0.222		.221				
AO	0.490	0.510		.500				
AP	1.250	1.270		1.258				
AQ	2.465	2.485		2.475				
AR	1.405	1.425		1.418				
AS	0.050	0.110		.080				
AT	0.300	0.360		.330				
AU	0.100	0.125		.110				
AV	0.220	0.280		.250 R				
AW	0.030	0.090		.060 R				
AX	0.010	0.030		.020				
AY	0.115	0.135		.125 R				
AZ	0.640	0.660		.650 R				
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				OK ✓				

Measured by:	MM	Date:	2019/01/30
Audited by:		Date:	
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	

DQA: _____ Date: 2019/01/30 *MO 19 Jan 2019*

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: <u>185911</u>		AGAINST DEPARTMENT/PROCESS	
Part No. <u>D5380-1</u>		Cross tube ☐ Water Jet ☐	
NCR No. <u>19-7202</u>		Small Fab ☐ Prod. Eng. Coord. ☐	
Date: <u>2019/01/30</u>		Finishing ☐ Rec/Store/Packaging ☐	
Step #: _____		Composite ☐ Supplier ☐	
DISPOSITION		Engineering ☐	
Rework ☐		Quality ☐	
Scrap ☒		Other ☐	
Use-as-is ☐			
Suspected Unapproved ☐			
Description Work Order Deviation		MRB (QSI042) Approval	
tool Broke and after		PD 19-03-05	
not the good "H" put		Completed By	
in the offset		M.M.	
		Lead hand / Supervisor	
		Approval Verification	
		Date: 19/01/30	
		QC / QA Coordinator	
		Approval	
		PD 19-03-05	
Root Cause		FAULT CATEGORY	
Environment ☐		Positioned Wrong ☐	
Design ☐		Outside Dimensions ☐	
Doc/Data ☐		Over/Under tolerance ☐	
Equip/Tooling ☒		Part Incorrect ☐	
Handling/Pre ☐		Part Lost/Missing ☐	
Material ☐		Part Moved ☐	
Internal Transport ☐		Drawing ☐	
Tribal Knowledge ☐		Finish ☐	
LOA ☐		Misread ☐	
Substation ☐		Turning Sequence ☐	
Past Expiry Date ☐			
Misidentified ☐			
No Re-verification ☐		Power Loss/Surge ☐	
Operator ☐		Folio/Program ☐	
Offset/Setup ☐		Grain ☐	
Supplier ☐		Weld ☐	
Training ☐		Wrong Stock Pulled ☐	
Use for Testing ☐		Out of Sequence ☐	
Poor Information ☐		Off-set ☐	
Rushing ☐		Mislabeled ☐	
Product Improvement ☐		Fit/Function ☐	
Process Improvement ☐		Misaligned/off center ☐	
Manufacturing Process ☐			
Past Due ☐			
OTHER: ☐			